

Date: Thursday, 09/10/2008 10:20:50 AM
 User: Julie Lecocq

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.			Drawing Name	: SEAT SUPPORT ASSEMBLY, RH		
Job Number	: 42522			Part Number	: D3784044		
Estimate Number	: 13329			Drawing Number	: D3784 REV B		
P.O. Number	:			Project Number	:		
This Issue	: 09/10/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: //	Type	: SMALL /MED FAB	Due Date	: 25/10/2008		
Previous Run	: 42521			Qty:	3		
Written By	:			Um:	Each		
Checked & Approved By	: JUO 08.10.09						
Comment	: Est Rev:A 08-05-19 new issue DD verified by:ec Est Rev:B 08-07-18 revB as per dwg DD verified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

2.0	D3763044	End Fitting Assembly, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

End Fitting Assembly, RH

batch: B40684

SB 08/10/15

③

3.0	D37701	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tube

batch: B40978

SB

4.0	D37703	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tube

batch: B40979

SB

5.0	D3763041	End Fitting Assembly
-----	----------	----------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

End Fitting Assembly

batch: B40952

SB 08/10/15

③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 09/10/2008 10:20:50 AM
User: Julie Lecocq

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: SEAT SUPPORT ASSEMBLY, RH

Job Number: 42522

Part Number: D3784044

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 MS21042L3

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: M108701

(10)

M105031

(2)

SB

7.0 AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M105793

(or NAS1149D0332J) batch:

SB

8.0 AN52510R20

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: M108559

SB 08/10/15 (3)

9.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-assemble as per dwg D3784

****Note 8: Hole "A" is located 5" from the end of D3770-3 tube and must be oriented down****

****Note 8: Hole "B" is located 5" from the end of D3770-1 tube and must be oriented forward****

SB 08/10/15 (3)

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/10/15 (3)

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # and batch # using a fine point permanent marker on inside of part and Stock

Location: ST 257

SB 08/10/16 (3)

12.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MF 08-10-16

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

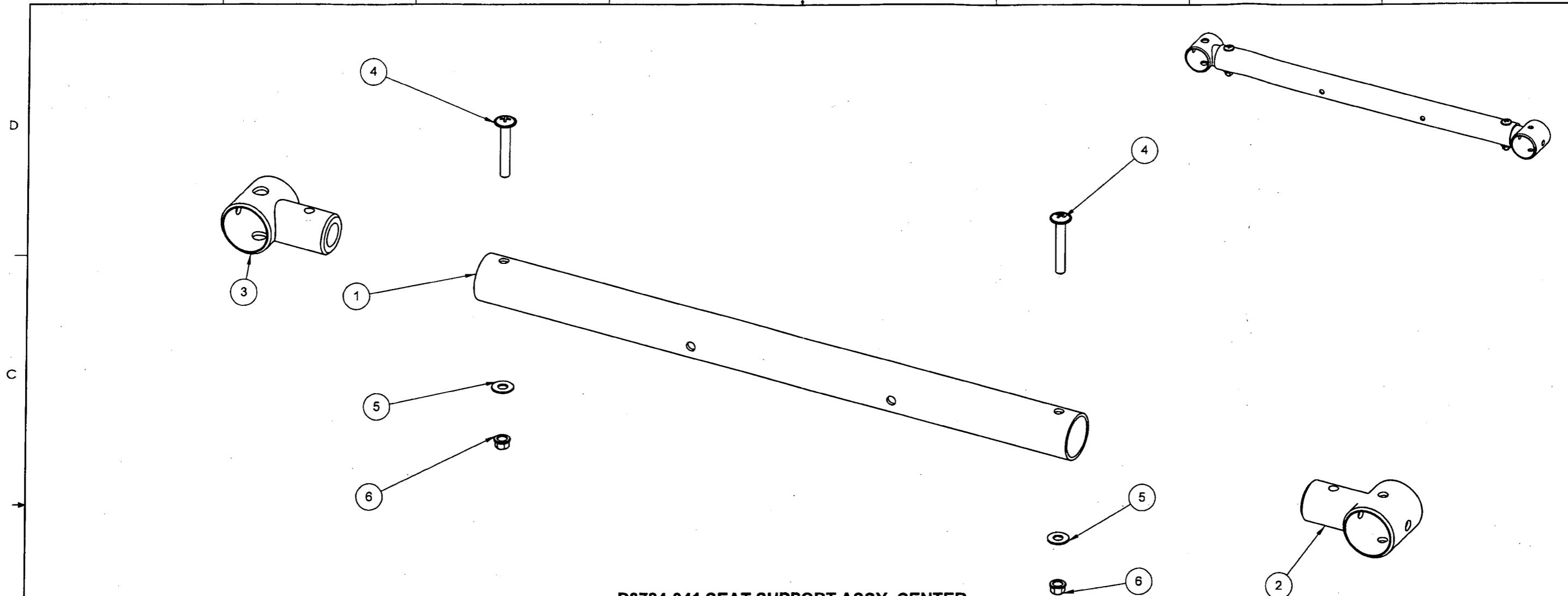
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D3784-041 SEAT SUPPORT ASSY, CENTER

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3770-1	TUBE	1
2	D3763-041	END FITTING ASSY	1
3	D3763-045	END FITTING ASSY	1
4	AN525-10R20	SCREW	2
5	NAS1149D0332J	WASHER (AN960JD10L)	2
6	MS21042L3	NUT	2

△
B
△
B
△
B

RELEASED
08.07.10 MHD

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WORK ORDER
NOT FOR SALE

B	HARDWARE CHANGE, ASSY CHANGE		HS	08.06.23		
A	NEW ISSUE		HS	08.06.04		
REV.	DESCRIPTION		BY	DATE		
DESIGN	HS	DART AEROSPACE LTD				
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA				
CHECKED	P4	DRAWING NO.	REV. B			
MFG. APPR.	M	D3784	SHEET 1 OF 5			
APPROVED		TITLE	SCALE			
DE APPR.		SEAT SUPPORT ASSEMBLY	NTS			
DATE	08.06.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD				
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NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

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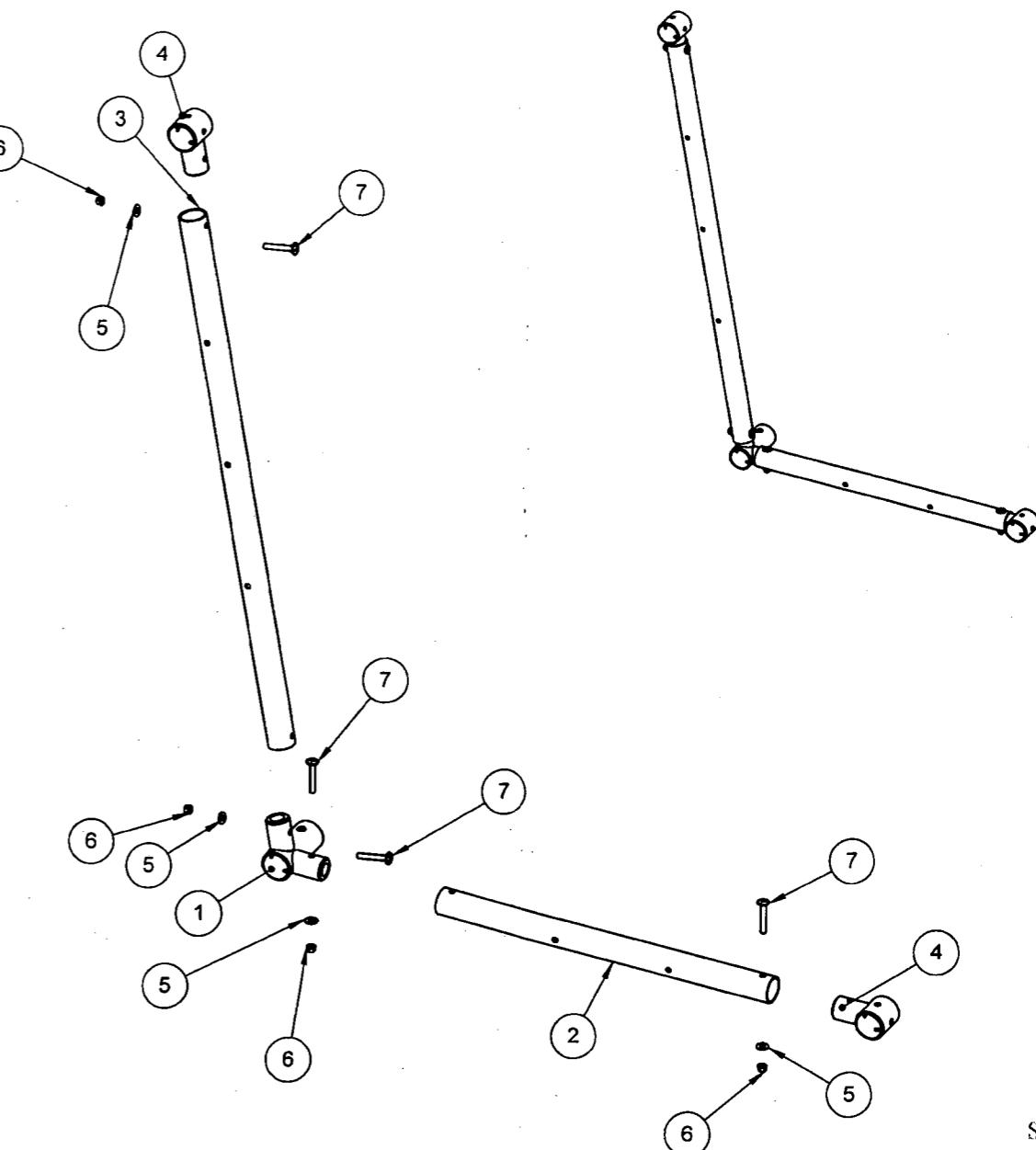
A

A

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3763-043	END FITTING ASSY, LH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	NAS1149D0332J	WASHER (AN960JD10L)	4
6	MS21042L3	NUT	4
7	AN525-10R20	SCREW	4

B
B
B

D3784-043 SEAT SUPPORT ASSY, LH



RELEASED
08-07-10 W
NO. 70520

NOTES:

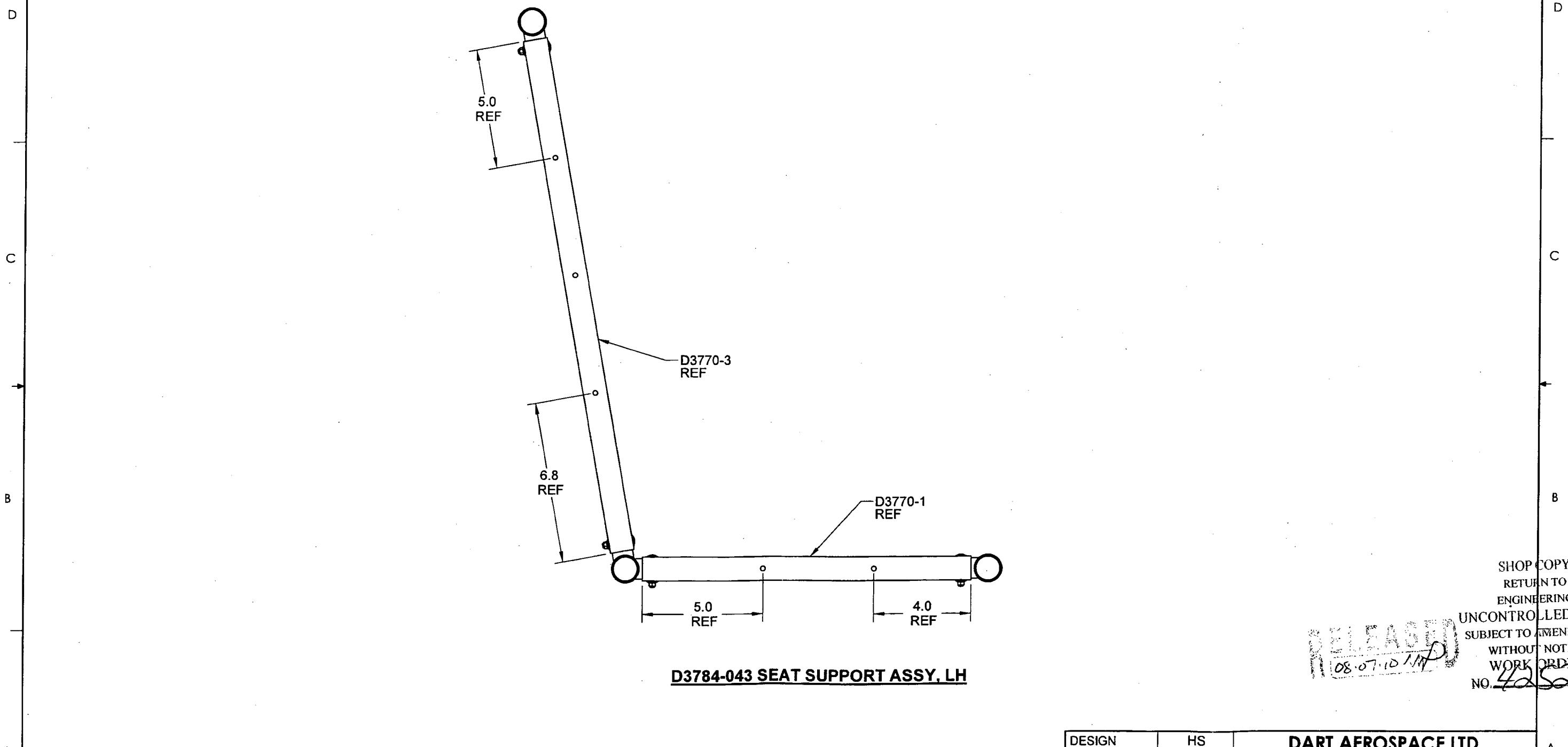
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	HS	
CHECKED	PJ	
MFG. APPR.	AN	
APPROVED	MM	
DE APPR.	MM	
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NO. 70520

8 7 6 5 4 3 2 1



D3784-043 SEAT SUPPORT ASSY, LH

RELEASER
08.07.10
NO. 42522

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	HS	
CHECKED	PS	DRAWING NO.
MFG. APPR.		REV. B
APPROVED		SHEET 3 OF 5
DE APPR.		TITLE
DATE	08.06.23	SCALE

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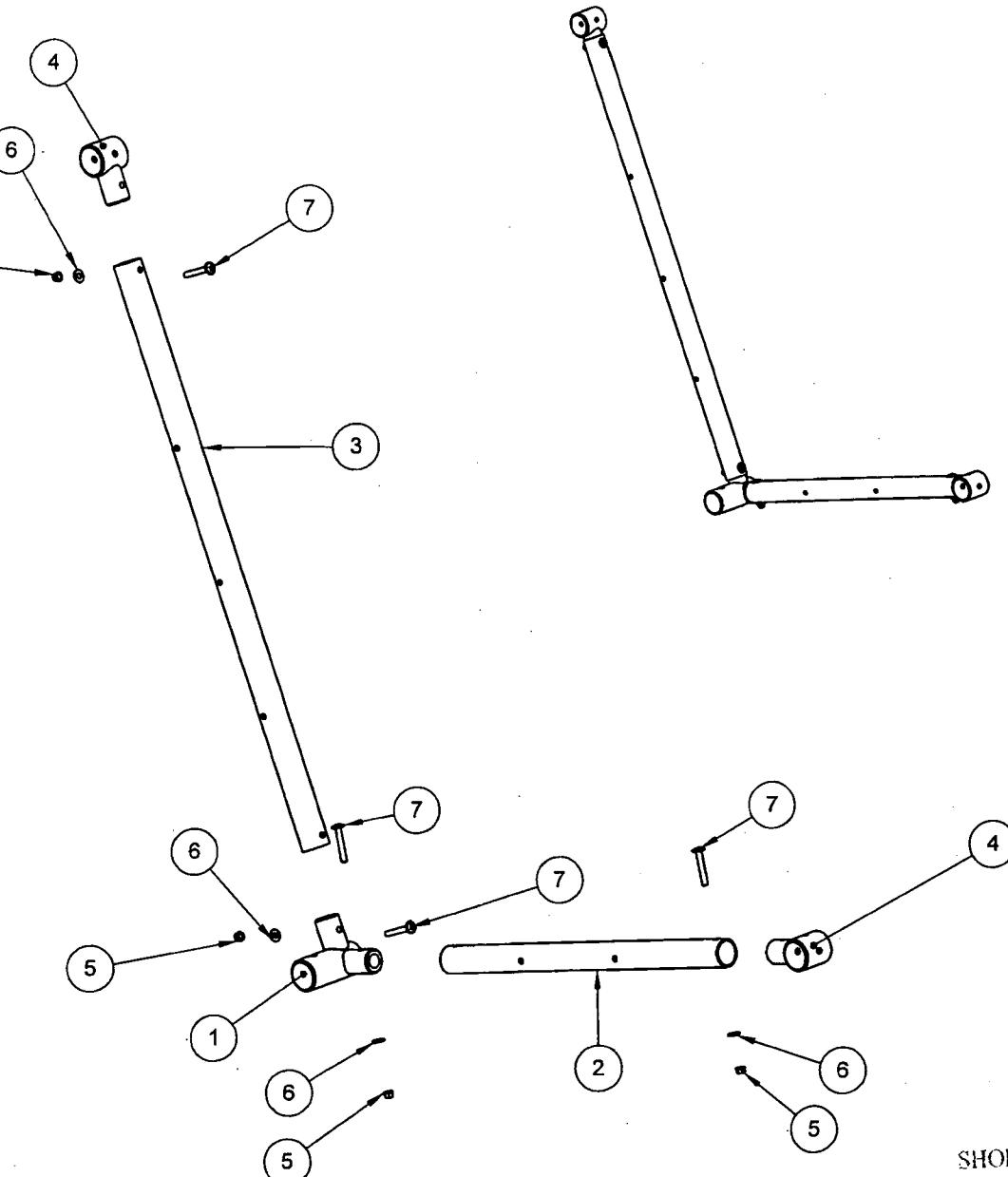
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A

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3763-044	END FITTING ASSY, RH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	MS21042L3	NUT	4
6	NAS1149D0332J	WASHER (AN960JD10L)	4
7	AN525-10R20	SCREW	4

B
B
B

D3784-044 SEAT SUPPORT ASSY, RH



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NO. 12520

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	HS	
CHECKED	PA	
MFG. APPR.	NO	
APPROVED	MM	
DE APPR.	MM	
DATE	08.06.23	DRAWING NO. D3784 REV. B SHEET 4 OF 5 TITLE SEAT SUPPORT ASSEMBLY SCALE NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>

8

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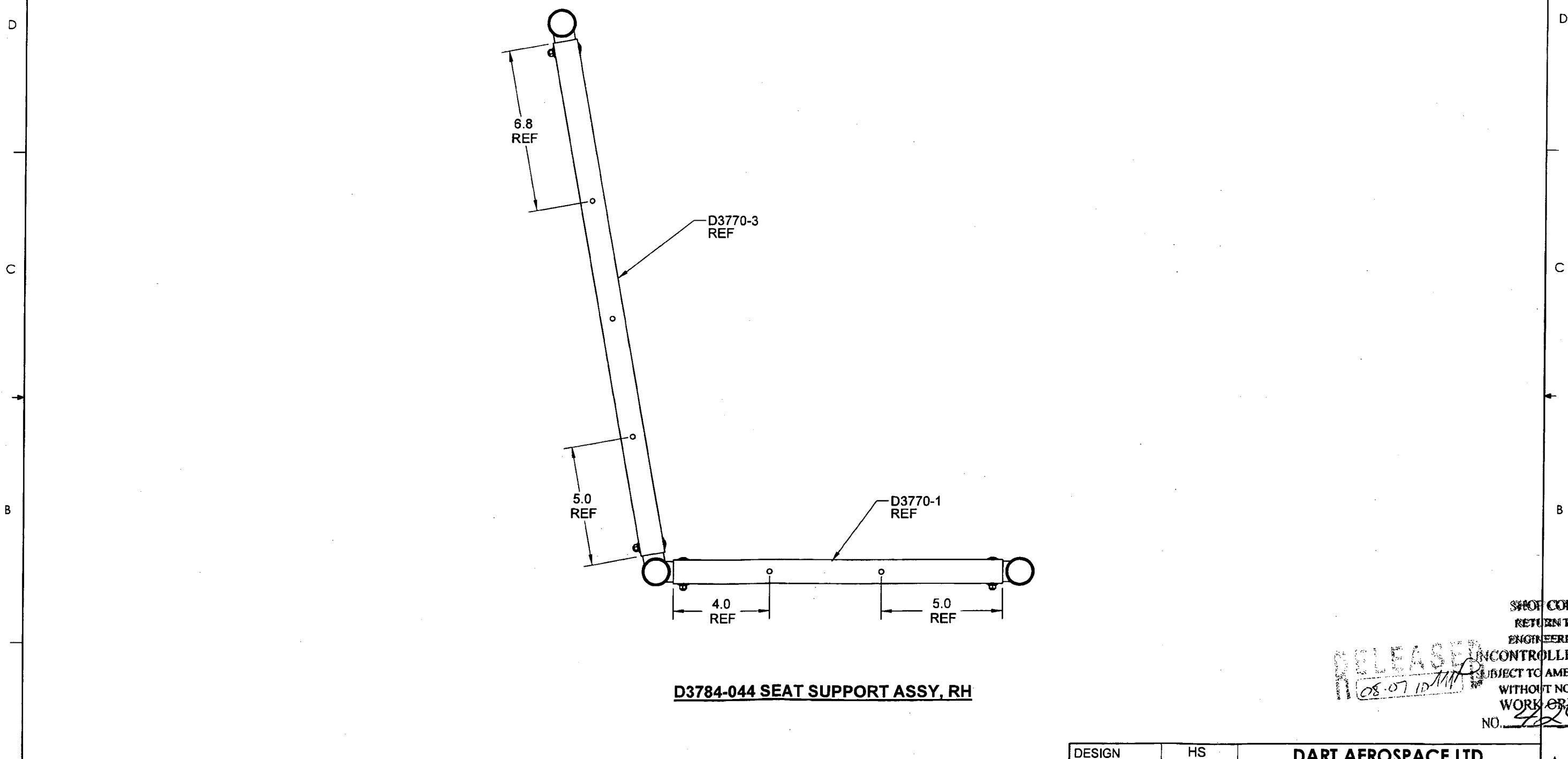
4

3

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1

8 7 6 5 4 3 2 1



D3784-044 SEAT SUPPORT ASSY, RH

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WORK ORDER
NO. 402522

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RS	DRAWING NO.	
MFG. APPR.	M	D3784	REV. B
APPROVED	Y	TITLE	SHEET 5 OF 5
DE APPR.		SEAT SUPPORT ASSEMBLY	SCALE
DATE	08.06.23	NTS	

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